

This Page Is Inserted by IFW Operations
and is not a part of the Official Record

BEST AVAILABLE IMAGES

Defective images within this document are accurate representations of the original documents submitted by the applicant.

Defects in the images may include (but are not limited to):

- BLACK BORDERS
- TEXT CUT OFF AT TOP, BOTTOM OR SIDES
- FADED TEXT
- ILLEGIBLE TEXT
- SKEWED/SLANTED IMAGES
- COLORED PHOTOS
- BLACK OR VERY BLACK AND WHITE DARK PHOTOS
- GRAY SCALE DOCUMENTS

IMAGES ARE BEST AVAILABLE COPY.

As rescanning documents *will not* correct images,
please do not report the images to the
Image Problem Mailbox.

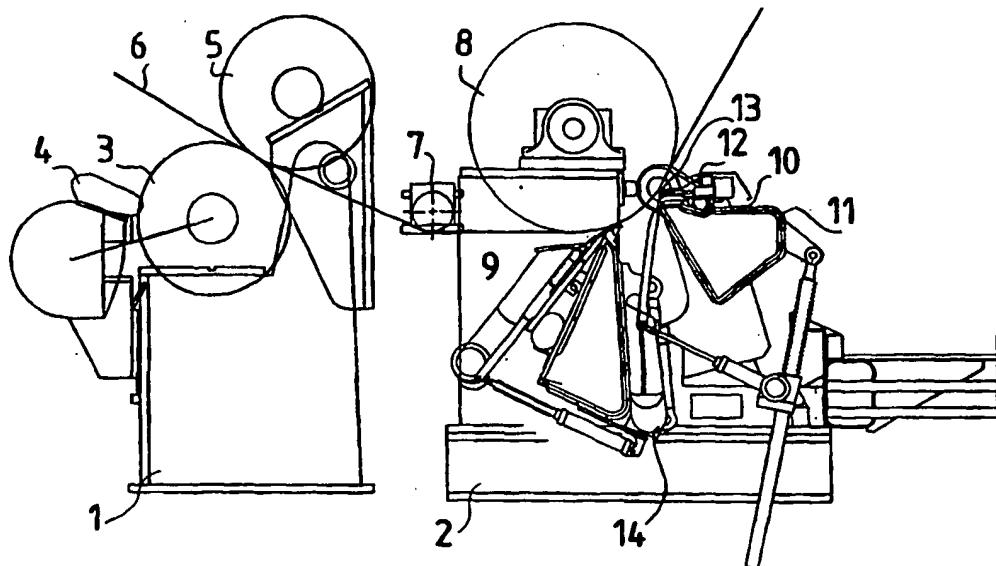
This Page Blank (uspto)



INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁶ :	A1	(11) International Publication Number:	WO 98/20202
D21H 23/32, 23/70, 23/50, B05C 1/08, 1/02		(43) International Publication Date:	14 May 1998 (14.05.98)
(21) International Application Number: PCT/FI97/00668		(81) Designated States: AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CU, CZ, DE, DK, EE, ES, FI, GB, GE, GH, HU, ID, IL, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, UA, UG, US, UZ, VN, YU, ZW, ARIPO patent (GH, KE, LS, MW, SD, SZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG).	
(22) International Filing Date: 31 October 1997 (31.10.97)		Published With international search report.	
(30) Priority Data: 964430 4 November 1996 (04.11.96) FI			
(71) Applicant (for all designated States except US): VALMET CORPORATION [FI/FI]; Panuntie 6, FIN-00620 Helsinki (FI).			
(72) Inventor; and			
(75) Inventor/Applicant (for US only): KUNI, Stefan [FI/FI]; Pietolankatu 15 as 6, FIN-04400 Järvenpää (FI).			
(74) Agents: LAINE, Seppo et al.; Seppo Laine Oy, Lönnrotinkatu 19 A, FIN-00120 Helsinki (FI).			

(54) Title: METHOD AND ARRANGEMENT FOR COATING A MOVING PAPERBOARD WEB



(57) Abstract

Method for coating a moving paperboard web (6) with at least two coating layers. In the method, a first coating layer is applied onto the surface of the web (6) and a second coating layer is applied onto the surface of this first undried coating layer. The first coating layer is applied by means of a film transfer coater (1) and the second coating layer is applied by means of a nozzle applicator (2), whereby the first layer is neither mixed nor doctoried off the web during the application of the second layer.

FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AL	Albania	ES	Spain	LS	Lesotho	SI	Slovenia
AM	Armenia	FI	Finland	LT	Lithuania	SK	Slovakia
AT	Austria	FR	France	LU	Luxembourg	SN	Senegal
AU	Australia	GA	Gabon	LV	Latvia	SZ	Swaziland
AZ	Azerbaijan	GB	United Kingdom	MC	Monaco	TD	Chad
BA	Bosnia and Herzegovina	GE	Georgia	MD	Republic of Moldova	TG	Togo
BB	Barbados	GH	Ghana	MG	Madagascar	TJ	Tajikistan
BE	Belgium	GN	Guinea	MK	The former Yugoslav Republic of Macedonia	TM	Turkmenistan
BF	Burkina Faso	GR	Greece	ML	Mali	TR	Turkey
BG	Bulgaria	HU	Hungary	MN	Mongolia	TT	Trinidad and Tobago
BJ	Benin	IE	Ireland	MR	Mauritania	UA	Ukraine
BR	Brazil	IL	Israel	MW	Malawi	UG	Uganda
BY	Belarus	IS	Iceland	MX	Mexico	US	United States of America
CA	Canada	IT	Italy	NE	Niger	UZ	Uzbekistan
CF	Central African Republic	JP	Japan	NL	Netherlands	VN	Viet Nam
CG	Congo	KE	Kenya	NO	Norway	YU	Yugoslavia
CH	Switzerland	KG	Kyrgyzstan	NZ	New Zealand	ZW	Zimbabwe
CI	Côte d'Ivoire	KP	Democratic People's Republic of Korea	PL	Poland		
CM	Cameroon	KR	Republic of Korea	PT	Portugal		
CN	China	KZ	Kazakhstan	RO	Romania		
CU	Cuba	LC	Saint Lucia	RU	Russian Federation		
CZ	Czech Republic	LI	Liechtenstein	SD	Sudan		
DE	Germany	LK	Sri Lanka	SE	Sweden		
DK	Denmark	LR	Liberia	SG	Singapore		
EE	Estonia						

Method and arrangement for coating a moving paperboard web

5 The present invention relates to a method according to the preamble of claim 1 for coating paperboard with at least two coating layers.

The invention also relates to an arrangement for implementing the method.

10 Paperboard can be coated with one or more coating layers in order to improve its printability. The more coating layers are applied, the higher the attained paper quality, simultaneously enabling the use of coating agents having 15 different properties. However, the use of two coating layers entails a significant increase in production costs because the coating is usually carried out in separate steps and the applied coating layer has been dried prior to the application of the next layer.

20 The coating can be performed either directly onto the board surface by means of e.g. a blade or a rod coater or by means of a film transfer coater whereby film which has been apportioned onto a film roll is transferred onto the paper 25 surface in a roll nip. It is typical of the blade and rod coating methods that the doctor blade fills the roughness volume of the coating underlayer and evens out the surface whereby the thickness of the coat varies in accordance with the roughness volume variations of the coating underlayer. 30 A smooth coat results having an uneven brightness coverage, and the uniform absorption properties of the coat are difficult to control.

In film transfer coating, a coat of an essentially more 35 uniform thickness is obtained rendering it easy to control

the absorption properties, but sufficient smoothness properties pose a problem particularly in the case of thicker papers and boards. The coating also provides quite an even coverage whereby, for example, the brightness of a 5 coating underlayer of low brightness can be significantly improved by means of this method. Furthermore, as no doctor blade trailing along the coating underlayer is involved in film transfer coating, the method offers excellent runnability as regards coating breaks.

10

When paperboard is manufactured furnished with two or several coating layers, the investment costs involved are significant, because the coated web must be dried prior to the application of the next layer. This results in great 15 length of the coating line wherefore it requires a lot of room in the factory hall. The drying also requires a significant amount of thermal energy. Thus, it would be of advantage to apply the second coating layer onto a wet or damp first layer without any intermediate drying step. 20 This, however, leads to problems in that the application and evening out of the second coating layer scrapes most of the first wet coating layer off the board surface and a thin final coat results, whereby at least some of the advantages of the duplex coating are lost.

25

The present invention aims at achieving a method by which a paperboard web can be provided with two coating layers without any intermediate drying.

30 The invention is based on applying a second coating layer onto the first coating layer by means of a nozzle applicator device. The first layer is advantageously applied by means of a film transfer coater.

In more detail, the method according to the invention is characterized by what is stated in the characterizing part of claim 1.

- 5 The apparatus according to the invention, then, is characterized by what is stated in the characterizing part of claim 13.

The invention offers considerable benefits.

10 The most important benefits attained by the invention relate to improving the quality of the coated paper board. The coating method according to the invention achieves better coverage resulting in good optical smoothness of the 15 surface. The coated surface obtained is very smooth and glossy. The unexpectedly good optical properties attained especially by means of one embodiment of the invention are based on the fact that, during the second coating step, the 20 coating particles are preoriented in the direction of the web surface, thus achieving good coverage and brightness properties. Combining this with a coating layer of uniform thickness obtained by means of a film transfer coater will achieve a surface of essentially more even colour than those produced by conventional methods. When performed by a 25 nozzle applicator device comprising a small-angle blade or by an application nozzle, the application of the second layer does not impose similar strain on the damp first layer as does, for example, short-dwell application, and thus, the first coating layer is not scraped off the web 30 surface when the second layer is applied. Thus, the solution according to the invention achieves a greater total coat weight than the previous wet-on-wet methods. By means of a film transfer coater, the web underside can be wetted in a controlled manner, thus avoiding warping of the

board caused by water absorption from the coat by the web. The wetting of the underside of the web can be done with the same apparatus as the actual coating. The duplex coating according to the invention provides considerable 5 savings in space compared to ordinary duplex coating where the web is dried prior to the application of the next layer. The invention is specially beneficial in coating paper board with a on-line coating apparatus since the web coming from the board making machine is usually hot whereby 10 the dry matter content rises rapidly when the coating mix of the first coating layer comes in contact with the hot web.

In addition to a film transfer coater, other methods can be 15 used to apply the first coating layer. It is a fact that a film transfer coater usually provides the best coating quality and good runnability, but a similar coating layer can be achieved by means of applicator roll and pool coaters, a curtain coater apparatus, and nozzle coating 20 devices and spray coaters, or even spray application devices. It is also feasible to use a device for applying the first coating layer, which evens out the coat by means of a doctor device, for example a short-dwell applicator, but this will achieve a poorer first-layer coverage than 25 the above-listed devices. Correspondingly, a smoother first-layer surface is attained, resulting in a smoother final surface.

In the following, the invention is described in more detail 30 by means of the annexed drawings.

Fig. 1 is a schematic side view of an arrangement according to the invention.

Fig. 2 is a schematic representation of a nozzle applicator device equipped with a pre-smoothing blade.

Fig. 3 depicts a nozzle applicator.

5

The present invention relates to a wet-on-wet coating method wherein a second coating layer is applied onto a wet first layer. In this context, the expression "wet first coating layer" is used to refer to a coating layer which 10 has not been actively dried before the application of the second layer.

The arrangement of Fig. 1 comprises a film transfer coater 1, a nozzle application device 2 and a doctor 10 and 15 spreader roll 7 fitted in connection with the same backing roll 8 as the nozzle application device 2. The film transfer coater 1 comprises a film transfer roll 3 and a backing roll 5 forming a nip therewith, as well as application means 4 for spreading the coating mix onto the 20 film transfer roll 4. Usually, an application device such as a short-dwell applicator is used as the application device 4, and most commonly, its doctor comprises a grooved rod. The application device may also be constituted by a short-dwell device equipped with a blade, or some other 25 similar means which can be used to obtain an even and accurately apportioned coating layer onto the surface of the film transfer roll 3. The web 6 to be coated travels through a nip formed by the film transfer roll 3 and the backing roll 5, wherein a coating layer adheres to the web 30 6 surface from the surface of the film transfer roll 3. The backing roll 5 comprises a dampening unit which can be used to apply water onto the roll surface so as to treat the underside of the web 6.

Fig. 2 is a blow-up of the nozzle applicator device 9 of the arrangement of Fig. 1, operating against a backing roll 8. The web 6 being coated travels between the backing roll 8 and the applicator 9. The applicator 9 comprises a pre-smoothing blade 15 fixed to a tool holder 17. The pre-smoothing blade 15 is adjusted at a small angle of about 0 to 25° in relation to the web 6 being coated, and thus, the coating mix applied onto the web 6 carries the blade 15 by means of hydrodynamic forces, resulting in relatively light scraping action. The scraping action is effected by means of a loading hose 16 adapted behind the pre-smoothing blade 15. The advantage of a small-angle blade lies in its relatively stable action even with large amounts of coating mix, this being of particular importance when coating board. In the production of high-quality printing boards, the large amount of coating mix is needed to achieve good printability, and some boards of poorer printability, such as packing board made of recycled fibers and unbleached board, must be coated with a thick coating layer because of the poor brightness of the base board, wherefore the coating is necessary in order to achieve at least reasonable printability.

The coating mix to be applied onto the web 6 is led to an application chamber 18 in the body of the device 9, and from there it is fed in as laminar a flow as possible to the root of the pre-smoothing blade 15. In the incoming direction of the web 6 the application chamber 18 is delimited by a lip 19 which in the operating position of the apparatus comes close to the web 6. A part of the coating brought to the pre-smoothing blade 15 sticks to the web 6 and a part flows back against the incoming direction of the web 6 preventing air inlet between the coat and the web at the application point. After the application, the

coat is doctored to its final thickness using a separate doctor 10. As the doctor 10, any suitable doctor that contacts the web, for example doctor blade, smooth or grooved doctor bar, can be used. In the case of Fig. 1, the 5 doctor is a trailing blade comprising a doctor blade 13 fixed to a frame beam 11 and loading and control means 12 for controlling the blade load and coat profile of the doctor blade 13.

- 10 The apparatus of Fig. 1 is used to manufacture duplex coated board. The board to be coated is first taken to a film transfer coater 1 which is used to apply a coating layer applied to the surface of the film transfer roll onto the web surface. This coating layer is of very uniform 15 thickness and it also closely follows the roughness profile of the web, and thus, uniform coverage is achieved by the film transfer coater. The web 6 absorbs water from the applied coating layer giving rise to warping and swelling of the web. Warping can be reduced by applying water to the 20 back side of the web, thus evening out the humidity of the web. The wetting of the web and the warping control is essential in board coating since the humidity gradients are steep because when the hot web is coated with wet coating, the absorption of water on the web is very different than 25 that of a thinner and cooler paper web. Longitudinal elongation of the web is easily controlled by web tension, and elongation in the cross-direction of the web is controllable by means of the spreading roll 7.
- 30 The second coating layer is spread onto the web surface by means of a nozzle applicator device equipped with a pre-smoothing blade 15. The coating layer applied using the film transfer apparatus is already partly dry because water contained in the coating mix is absorbed by the web. The

second coating layer is applied onto this slightly set layer. However, the first coating layer is still quite damp and will not endure a strong application pressure pulse. Therefore, nozzle application has been selected as the 5 method used in applying the second layer. After the application of the second layer, the coating is doctored in the conventional manner to its final thickness by means of a doctor blade fitted in connection with the same backing roll 8. Superfluous coating mix flows from the doctor blade 10 into a collector tray 14 and is returned to circulation from there. The distance between the nozzle applicator and the doctor blade can be adjusted whereby this adjustment of the setting time prior to doctoring can be used to influence the result of the doctoring. The amount of 15 coating mix applied in nozzle application is relatively small, and thus, the doctoring force required is, correspondingly, smaller than that required in, e.g. roll application, wherefore the risk of the first coating layer being doctored off is reduced.

20

In addition to the above, the present invention provides other embodiments as well.

Fig. 3 depicts a jet-type applicator device which can be 25 used instead of an applicator equipped with a pre-smoothing blade. In jet application, the coating mix is fed onto the web 6 through a narrow nozzle orifice 24 without the support of a pre-smoothing blade or the like. The nozzle orifice 24 is formed by an upper lip 21 and a lower lip 20 30 in the incoming direction of the web 6, the position and site of which can be altered to influence the breadth and position of the jet. The coating mix is fed to the nozzle orifice 23 through a narrow nozzle passage 23. The purpose of the nozzle passage 23 is to make the coating mix flow as

laminar as possible in order to achieve an even coating jet. In jet application, the aim is to control the amount of coating mix such that the entire flow of coating mix from the nozzle orifice 24 is taken onto the web 6 to form an application layer 22, and thus, essentially no reflux flow occurs. In jet application, no application pressure pulse occurs, wherefore it is well suited for the application of a second layer onto an undried first layer of coating mix.

In the arrangement of the invention, other known nozzle application means may also be used. In this context, the term 'nozzle application means' is used to refer to an apparatus with an extrusion die and possibly a pre-smoothing device but no doctor. The distance between the film transfer coater and the nozzle application may be adjustable, whereby the absorption of water by the web can be controlled by altering the delay time between the coating steps by means of adjusting the distance.

In order to prevent the web from warping, a dampener unit may be fitted in connection with one or both of the backing rolls 5, 8, the dampener unit being used to apply water to the uncoated surface of the web 6. The doctor can be omitted from the arrangement for instance when a nozzle applicator is used to apply a coat of desired thickness directly onto the web surface.

As already stated in the introductory part of the application, various means may be used to apply the first coating layer, those forming an applied layer of uniform thickness, e.g. roll coaters, being the best suited. The most advantageous method for applying the first layer would seem to comprise film transfer coating, and in some cases,

methods comprising the use of a doctor blade or rod for smoothing are possible, this, however, changing the quality of the coat.

Claims:

1. A method for coating a moving board web (6) with at least two coating layers, whereby:

5

- a first coating layer is applied onto the web (6) surface, and

10

- a second coating layer is applied onto the first undried coating layer,

characterized by applying the second coating layer by means of a nozzle applicator (2).

15

2. The method of claim 1, characterized by applying the second coating layer by means of a nozzle applicator (2) furnished with pre-smoothing means (15).

20

3. The method of claim 1, characterized by applying the second coating layer by means of a jet applicator.

25

4. The method of any one of the previous claims, characterized by applying the first layer by means of a film transfer coater (1).

5. The method of any one of the previous claims 1 to 3, characterized by applying the first coating layer by means of a applicator roll coater.

30

6. The method of any one of the previous claims 1 to 3, characterized by applying the first coating layer by means of a nozzle coating device.

7. The method of any one of the previous claims 1 to 3, characterized by applying the first coating layer by means of a spray coating device.
- 5 8. The method of any one of the previous claims 1 to 3, characterized by applying the first coating layer by means of a pool coating device.
- 10 9. The method of any one of the previous claims 1 to 3, characterized by spreading the first coating layer by means of a curtain coater device.
- 15 10. The method of any one of the previous claims, characterized by altering the distance between the first coater (1) and the nozzle applicator (2).
- 20 11. The method of claim 10, characterized by doctoring the coating layer to its final thickness when the web (6) travels on the same backing roll (8) against which the second coating layer is applied, and altering the distance between the application and the doctoring.
12. The method of any one of the previous claims, characterized by doctoring the coat to its final thickness after the application of the second coating layer.
- 25 13. An arrangement for coating a moving board web (6) with at least two coating layers, the arrangement comprising
- 30 - a device (1) for applying a first coating layer onto the web (6) surface, and
- a device (2) for applying a second coating layer

onto the surface of the first, undried coating layer,

5 c h a r a c t e r i z e d in that the device for applying
the second coating layer is a nozzle application device
(2).

10 14. The arrangement of claim 13, c h a r a c t e r i z e d
in that the device for applying the second coating layer is
a nozzle application device (2) equipped with pre-smoothing
means (15).

15 15. The arrangement of claim 13, c h a r a c t e r i z e d
in that the device for applying the second coating layer is
a jet applicator.

20 16. The arrangement of any one of the previous claims 13 to
15, c h a r a c t e r i z e d in that the device for
applying the first coating layer is a film transfer coater
(1).

25 17. The arrangement of any one of the previous claims 13 to
15, c h a r a c t e r i z e d in that the device for
applying the first coating layer is a applicator roll
coater.

30 18. The arrangement of any one of the previous claims 13 to
15, c h a r a c t e r i z e d in that the device for
applying the first coating layer is a nozzle coating
device.

19. The arrangement of any one of the previous claims 13 to
15, c h a r a c t e r i z e d in that the device for
applying the first coating layer is a spray coating device.

20. The arrangement of any one of the previous claims 13 to 15, characterized in that the device for applying the first coating layer is a pool coater.
- 5 21. The arrangement of any one of the previous claims 13 to 15, characterized in that the device for applying the first coating layer is a curtain coater device.
- 10 22. The arrangement of any one of the previous claims 13 to 21, characterized by means for altering the distance between the first coater (1) and the nozzle applicator (2).
- 15 23. The arrangement of any one of the previous claims 13 to 22, characterized by doctor means (10 - 13) for evening out the coat to its final thickness.
- 20 24. The arrangement of claim 23, characterized in that the doctor means (10 - 13) is arranged to operate against the same backing roll (8) as the second coat applicator, and the arrangement comprises means for altering the distance between the application and the doctoring.
- 25 25. The Arrangement according to the claim 23, characterized in that the doctor (10 - 13) is a contacting doctor, such as a doctor blade, smooth doctor bar or a grooved doctor bar.

1/3

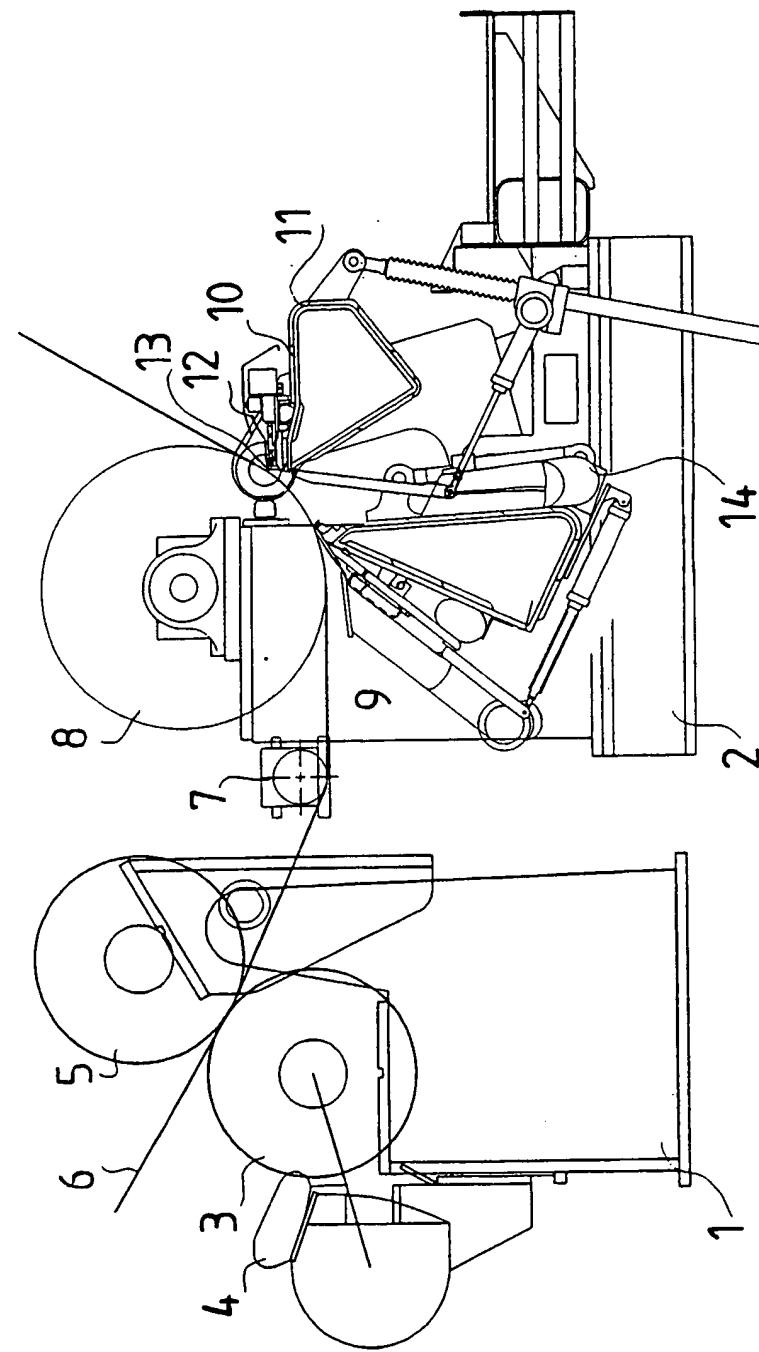
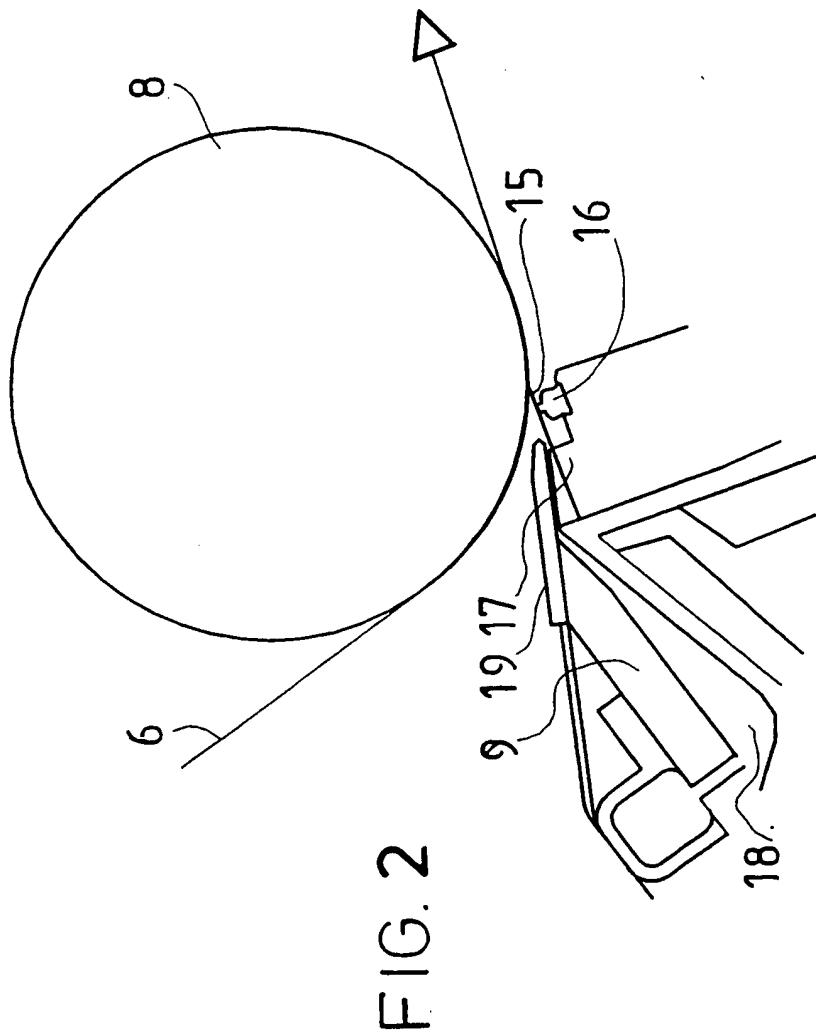


FIG. 1

2/3



3/3

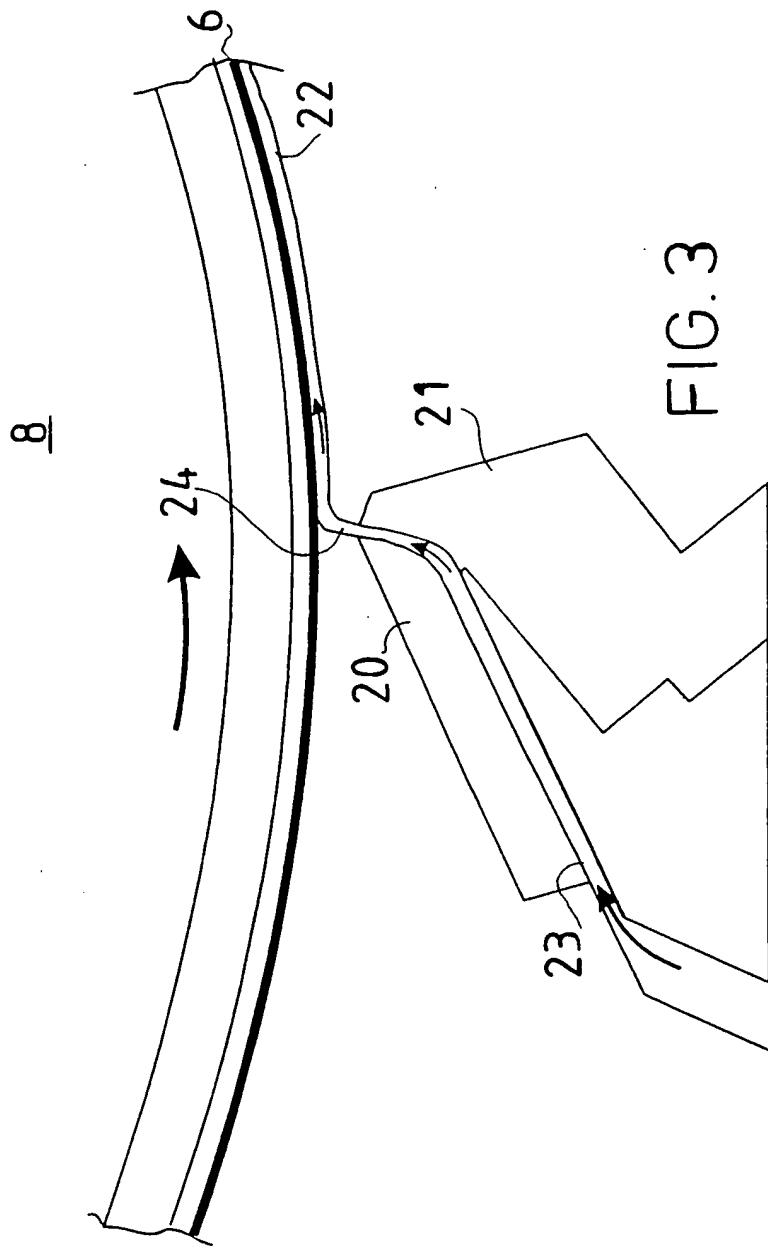


FIG. 3

INTERNATIONAL SEARCH REPORT

International application No.

PCT/FI 97/00668

A. CLASSIFICATION OF SUBJECT MATTER

IPC6: D21H 23/32, D21H 23/70, D21H 23/50, B05C 1/08, B05C 1/02
 According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC6: D21H, B05C

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

SE,DK,FI,NO classes as above

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

WPI

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	WO 9512031 A1 (J.M. VOITH GMBH), 4 May 1995 (04.05.95) --	1-25
Y	US 5510150 A (JUKKA KOSKINEN), 23 April 1996 (23.04.96) --	1-12
Y	US 5588998 A (JUKKA KOSKINEN), 31 December 1996 (31.12.96) --	13-25
A	EP 0791686 A1 (VALMET CORPORATION), 27 August 1997 (27.08.97) --	1-25

 Further documents are listed in the continuation of Box C. See patent family annex.

- * Special categories of cited documents:
- "A" document defining the general state of the art which is not considered to be of particular relevance
- "E" earlier document but published on or after the international filing date
- "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- "O" document referring to an oral disclosure, use, exhibition or other means
- "P" document published prior to the international filing date but later than the priority date claimed

- "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
- "X" document of particular relevance: the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
- "Y" document of particular relevance: the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
- "&" document member of the same patent family

Date of the actual completion of the international search

19 February 1998

Date of mailing of the international search report

20 -02- 1998

Name and mailing address of the ISA/
 Swedish Patent Office
 Box 5055, S-102 42 STOCKHOLM
 Facsimile No. +46 8 666 02 86

Authorized officer
 Eva Johansson
 Telephone No. +46 8 782 25 00

INTERNATIONAL SEARCH REPORT

International application No.

PCT/FI 97/00668

C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	EP 0130814 A2 (ACUMETER LABORATORIES INC.), 9 January 1985 (09.01.85) --	1-25
Y	EP 0438743 A1 (J.M. VOITH GMBH), 31 July 1991 (31.07.91) --	1-25
A	US 4921729 A (NOBUYOSHI KANEKO ET AL), 1 May 1990 (01.05.90) --	1-25
A	US 2937955 A (JOSEPH T. LOOMER), 24 May 1960 (24.05.60) -----	1-25

INTERNATIONAL SEARCH REPORT

Information on patent family members

03/02/98

International application No.

PCT/FI 97/00668

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
WO 9512031 A1	04/05/95	BR 9307830 A CA 2101358 A EP 0675984 A FI 953126 A JP 8508676 T US 5436030 A US 5603767 A	28/11/95 12/03/94 11/10/95 22/06/95 17/09/96 25/07/95 18/02/97
US 5510150 A	23/04/96	CA 2108841 A DE 4336365 A FI 924841 A FR 2697176 A,B GB 2272390 A,B JP 6198242 A SE 9303494 A US 5588998 A	27/04/94 28/04/94 27/04/94 29/04/94 18/05/94 19/07/94 27/04/94 31/12/96
US 5588998 A	31/12/96	CA 2108841 A DE 4336365 A FI 924841 A FR 2697176 A,B GB 2272390 A,B JP 6198242 A SE 9303494 A US 5510150 A	27/04/94 28/04/94 27/04/94 29/04/94 18/05/94 19/07/94 27/04/94 23/04/96
EP 0791686 A1	27/08/97	CA 2198339 A FI 960924 A JP 9314016 A	28/08/97 29/08/97 09/12/97
EP 0130814 A2	09/01/85	JP 60051572 A US 4569864 A	23/03/85 11/02/86
EP 0438743 A1	31/07/91	SE 0438743 T3 CA 2035061 A DE 4002256 A DE 59003011 D ES 2044390 T JP 4313360 A NO 176676 B,C US 5340611 A	27/07/91 01/08/91 00/00/00 01/01/94 05/11/92 30/01/95 23/08/94
US 4921729 A	01/05/90	JP 63091171 A	21/04/88
US 2937955 A	24/05/60	NONE	